

# HiFill® ABS GF60 LE

Acrylonitrile Butadiene Styrene

Techmer Engineered Solutions

## Message:

HiFill® ABS GF60 LE is an Acrylonitrile Butadiene Styrene (ABS) product filled with 60% glass fiber. It can be processed by injection molding and is available in North America. Typical application: Food Contact Applications. Primary characteristic: flame rated.

General Information			
Filler / Reinforcement	Glass Fiber,60% Filler by Weight		
Features	Low Extractables		
Agency Ratings	FDA Unspecified Rating		
Appearance	Colors Available		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.62	g/cm <sup>3</sup>	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.050	%	ASTM D955
Water Absorption (24 hr)	0.080	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	125		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	117	MPa	ASTM D638
Tensile Elongation (Break)	2.0	%	ASTM D638
Flexural Modulus	12800	MPa	ASTM D790
Flexural Strength	145	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	69	J/m	ASTM D256
Unnotched Izod Impact (3.18 mm)	320	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	113	°C	
1.8 MPa, Unannealed	107	°C	
CLTE - Flow	1.3E-5	cm/cm/°C	ASTM D696
Flammability	Nominal Value		Test Method
Flame Rating	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	76.7 to 87.8	°C	
Drying Time	2.0 to 16	hr	
Rear Temperature	216 to 232	°C	
Middle Temperature	221 to 238	°C	

Front Temperature	210 to 221	°C
Nozzle Temperature	199 to 221	°C
Processing (Melt) Temp	232 to 260	°C
Mold Temperature	71.1 to 87.8	°C

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